

Work Order ID 78682 - 1

\*78682\*

Page 1

January-12-12 10:55:33 AM

Item ID: D206-628-013

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Heli-Access-Step LH

Stop \*NS2\*

Start Date: 12/01/2012 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: *MCJ* Date: 12/01/12 Tooling:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9500	A
IIN-D206-628	Rev F

100 DOCUMENT CONTROL *SD* 0.00

\*100\*

DC Memo 0.00

Document Control Photocopy blue file and type labels as per PPP D206-628-013 CHG 006 *6*

*12/3/12*

*Form 12-3-6 (4)*

*Pro →*

110 Pick Kit 0.00

\*110\*

Packaging Memo 0.00

Packaging

*12/3/12*

*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-628-013 PAR #: \_\_\_\_\_ Fault Category: Prod Eng. NCR: Yes No DQA: Aut Date: 12/3/7  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: MLJ Date: 12/08/07

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/3/06	# 10D	Part missing on w/o to I Z W. R.C. w/o creates incorrect	h 12/03/07	ADD missing Part to Kit was 1149C0432R M <u>117291</u> at + 8 Per Kit	sd 12/3/7	S 12/03/7	h 12/03/07	S 12/03/06
				correctly update Bom + w/o ADD copy of Bom for Ref.				S 12/03/06

NOTE: Date & initial all entries

# WORK ORDER CHANGES

78682

STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D266-628-013 PAR #:          Fault Category: Prod Eng. NCR: Yes No DQA: At2 Date: 12/3/7  
 12-1270 Resolution: Rework Disposition: Rework QA: N/C Closed: NLS Date: 12/03/07

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/3/06	#100	Part missing on w/o to I Z W. R.C. w/o creates incorrect	<i>h</i> 12/3/07	ADD MUSH Part to Kit WAS 11490432R in 117291 at x 8 per Kit	<i>sd</i> 12/3/7	<i>S</i> 12/3/7	<i>h</i> 12/3/07	<i>S</i> 12/3/06
				correctly update Bom + w/o ADD copy of Bom for Ref.				<i>S</i> 12/3/06

NOTE: Date & initial all entries

**Work Order ID 78682****\*78682\***

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January-12-12 10:55:33 AM

Item ID: D206-628-013

Accept

**\*N19000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step LH

Start Date: 12/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Packaging

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-013

Location:

PPP Rev: 672

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/3/12 (2)MLC 12/03/07MLC  
12-03-07

## Picklist Print

January-12-12 10:55:37 AM

Work Order ID: 78682

\*78682\*

Parent Item: D206-628-013

\*D206-628-013\*

Parent Item Name: Heli-Access-Step LH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:D As Per Ecn 766 06-01-06 JLM  
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:  
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP  
 Rev:G per DSI9500 DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A

Purchased

No

110

Each

3,002.000

2

8

\*\*

\*AN3C4A\*

BOLT

## Location

## Loc Qty

## Loc Code

ST350

3002

117313

2

117688

5

117872

10

118112

16

118451

2

118838

13

119749

954

120187

2000

AN4C13A

Purchased

No

110

Each

60.0000

4

16

\*\*

\*AN4C13A\*

BOLT

## Location

## Loc Qty

## Loc Code

ST357

60

120187

60

AN4C14A

Purchased

No

110

Each

94.0000

4

16

\*\*

\*AN4C14A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST357

94

118706

94



# Picklist Print

January-12-12 10:55:37 AM

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Work Order ID: 78682

\*78682\*

Parent Item: D206-628-013

\*D206-628-013\*

Parent Item Name: Heli-Access-Step LH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

110

Each

109.0000

4

16

\*AN4C15A\*

Bolt

\*\*

Location

Loc Qty

Loc Code

ST358

109

115835

2

118628

7

118706

100

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

16

64

\*AN960C416\*

washer

D2731-7

Manufactured

No

110

Each

54.0000

4

16

\*D2731-7\*

Mounting Lug

\*\*

\*\*

Location

Loc Qty

Loc Code

ST468A

4

71860

4

ST469

50

D2732-030

Manufactured

No

110

Each

4.0000

8

32

\*D2732-030\*

Rubber Cushion

\*\*

Location

Loc Qty

Loc Code

ST402

4

64283

4

D2841-041

Manufactured

No

110

Each

0.0000

1

4

\*D2841-041\*

Step Assembly, 206 Float

\*\*

January-12-12 10:55:38 AM

Shop Packet Print

Page 2

# Picklist Print

January-12-12 10:55:38 AM

Work Order ID: 78682

\*78682\*

Parent Item: D206-628-013

\*D206-628-013\*

Parent Item Name: Heli-Access-Step LH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2845 Manufactured No

110 Each

33.0000

2 8

\*\*

\*D2845\*

Arm

Location

Loc Qty

Loc Code

ST265

33

52269

13

56828

20

D3394-043 Manufactured No

110 Each

27.0000

4 16

\*\*

\*D3394-043\*

Lug Assembly

Location

Loc Qty

Loc Code

ST479

27

74493

27

D4064-041 Manufactured No

110 Each

21.0000

1 4

\*\*

\*D4064-041\*

Mounting Lug

Location

Loc Qty

Loc Code

ST465

21

58980

4

58985

1

62977

16

# Picklist Print

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Work Order ID: 78682

\*78682\*

Parent Item: D206-628-013

\*D206-628-013\*

Parent Item Name: Heli-Access-Step LH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

110

Each

1,038.000

12

48

\*\*

M117793

M120388

\*MS21043-4\*

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

528

119309

32

119546

496

NAS1149C0363R

Purchased

No

110

Each

3,706.000

2

8

\*\*

M114742

\*NAS1149C0363R\*

Washer

Location

Loc Qty

Loc Code

ST297

3706

114742

3706

NAS1515H3

Purchased

No

110

Each

151.0000

2

8

\*\*

12/13/12

\*NAS1515H3\*

Washer

Location

Loc Qty

Loc Code

ST277

151

116373

6

118078

6

118384

11

119438

28

120142

100

January-12-12 10:55:38 AM

Shop Packet Print

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# Picklist Print

January-12-12 10:55:38 AM

Work Order ID: 78682

\*78682\*

Parent Item: D206-628-013

\*D206-628-013\*

Parent Item Name: Heli-Access-Step LH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4L

Purchased

No

110

Each

190.0000

24

96

\*\*

12/3/6 SD

\*NAS1515H4I \*

WASHER

Location

Loc Qty

Loc Code

FG

8

103691

8

ST277

182

118709

182

96

# REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628

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## 5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

## 5.3 QUICK RELEASE PIP PIN KIT

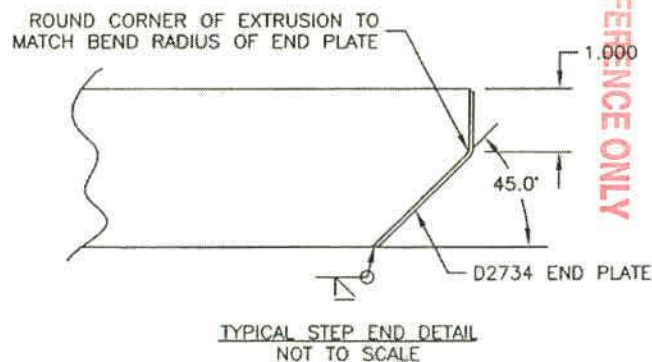
Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

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Revision: G  
Date: 11.02.25



DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2841	REV. B SHEET 1 OF 1
DATE 05.09.21	TITLE 206B FLOAT STEP ASSEMBLY SCALE NTS		
A	98.10.14	NEW ISSUE	
B	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7	



QTY	QTY	PART NUMBER	DESCRIPTION
- 041	- 042		
X		D2841-041	LH STEP ASSEMBLY
	X	D2841-042	RH STEP ASSEMBLY
1	1	D2522-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3454-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	HA51329C3K6130	INSERT
		(OR AESS10K8130)	
4	4	M527039C1-07	SCREW
4	4	NA51515H3L	WASHER
4	4	AN960C-10L	WASHER

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED

05-11-14

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